

Express Mail Label No. EV 655365775 US
Application No. 10/670,091
Atty. Docket No. 4811-9-CON

AMENDMENTS TO THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently Amended) A flocked assembly, comprising flock and a pre-formed, solid, continuous, and self-supporting thermosetting film, wherein the flock is in contact with and adhered to the thermosetting film, and wherein the thermosetting film is free of an acrylic adhesive, wherein substantially all free ends of the flock contact the thermosetting film, and wherein the thermosetting film has a substantially uniform thickness and substantially flat upper and lower surfaces.
2. (Original) A transfer comprising the flocked assembly of claim 1.
3. (Previously Presented) The flocked assembly of claim 2, wherein first ends of said flock is adhered to a release sheet by a release agent and wherein the thermosetting film contacts opposing second ends of the flock.
4. (Previously Presented) The transfer of claim 3, wherein said transfer is adhered to a substrate and wherein the transfer is free of a hot melt adhesive.
5. (Previously Presented) The transfer of claim 4, wherein said transfer is adhered to said substrate by the thermosetting film and wherein the thermosetting film comprises a thermosetting polyester.
6. (Previously Presented) The flocked assembly of claim 1, wherein the thermosetting film is a thermosetting polyurethane film or a thermosetting polyester film.

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7. (Previously Presented) The flocked assembly of claim 1, wherein the thermosetting film is precut to correspond to a shape of the transfer and wherein the thermosetting film is a thermosetting polyurethane.

8. (Previously Presented) The flocked assembly of claim 3, wherein the release agent and release sheet are located on a first surface of the flock and the thermosetting film is positioned on a second surface of the flock and the first and second surfaces are in an opposing relationship.

9. (Previously Presented) The flocked assembly of claim 1, wherein the thermosetting film is crosslinked.

10. (Previously Presented) The flocked assembly of claim 1, wherein there is no binder adhesive located between the thermosetting film and the flock.

11. (Previously Presented) The flocked assembly of claim 1, wherein the thermosetting film is applied to a substrate and the thermosetting film preformed before application to the flock and substrate.

12. (Previously Presented) The flocked assembly of claim 1, wherein the thermosetting film is not fully crosslinked.

13. (Previously Presented) The flocked assembly of claim 1, wherein the flock is in direct physical contact with the thermosetting film.

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14. (Previously Presented) The flocked assembly of claim 1, wherein the thermosetting film is not fully activated.

15. (Withdrawn) A method of producing an article of manufacture having a flocked surface, the method comprising:

- (a) supplying flock;
- (b) supplying a preformed solid thermosetting film;
- (c) heating the flock and thermosetting film to adhere said flock to the thermosetting film, wherein said flock is formed in a desired pattern on the thermosetting film.

16. (Withdrawn) The method of claim 15, wherein in said supplying step (a) said flock is adhered to a release sheet by a release agent.

17. (Withdrawn) The method of claim 16, further comprising:

- (d) adhering the thermosetting film to a substrate to adhere the flock to the substrate.

18. (Withdrawn) The method of claim 16 wherein the step of adhering the thermosetting film to the flocked release sheet comprises heating the thermosetting film to a temperature at which the thermosetting film becomes tacky, but below a temperature at which the thermosetting film begins to cure and cross-link.

19. (Withdrawn) The method of claim 18 wherein the step of adhering the thermosetting film to the substrate comprises heating the thermosetting film to a temperature at which the thermosetting film cures and cross-links.

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20. (Withdrawn) The method of claim 19 wherein the thermosetting film is heated to about 300°F.

21. (Withdrawn) The method of claim 17 wherein the step of adhering the thermosetting film to the flocked release sheet and the step of adhering the thermosetting film to the substrate are performed substantially simultaneously in a single operation.

22. (Withdrawn) The method of claim 15 wherein the thermosetting film is a thermosetting polyurethane film or a thermosetting polyester film.

23. (Withdrawn) The method of claim 17, wherein the substrate, thermosetting film, and flocked release sheet are brought together substantially simultaneously to form a pre-assembly and further comprising:

- (d) applying heat to the pre-assembly to permanently adhere the flock to the substrate; and
- (e) removing the release sheet from the flock to produce a flocked substrate.

24. (Withdrawn) The method of claim 23 including a step of applying pressure to the pre-assembly.

25. (Withdrawn) The method of claim 23 wherein the step of applying heat comprises heating the pre-assembly to about 300°F.

26. (Withdrawn) The method of claim 23 wherein the thermosetting film is a thermosetting polyester or a thermosetting polyurethane.

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27. (Withdrawn) The method of claim 23 further comprising a step of cutting the flocked substrate to desired lengths to form articles.

28. (Withdrawn) The method of claim 23 further comprising a step of collecting the flocked substrate on a product roll.

29. (Canceled) A flocked article manufactured by the steps of claim 15.

30. (Withdrawn) A method for producing an article of manufacture having a flocked surface, the method comprising:

providing flock;

providing a thermosetting film;

providing a substrate;

bringing the substrate, thermosetting film, and the flock together with the thermosetting film positioned between the flock and the substrate and with the flock and substrate each being in contact with the thermosetting film, to form a pre-assembly;

applying heat and pressure to the pre-assembly to cross-link the thermosetting film and adhere the flock to the substrate; and

removing the release sheet from the flock to produce a flocked substrate.

31. (Withdrawn) The method of claim 30 wherein there is no binder adhesive between the flock and the thermosetting film.

32. (Withdrawn) The method of claim 30 wherein the thermosetting film is a thermosetting polyester or a thermosetting polyurethane.

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33. (Withdrawn) The method of claim 30 wherein the thermosetting film comprises a thermosetting polyester.

34. (Withdrawn) The method of claim 30 wherein the thermosetting film comprises a thermosetting polyurethane.

35. (Withdrawn) The method of claim 30 wherein the applying step comprises heating the thermosetting film to a temperature at which the thermosetting film cures and cross-links.

36. (Withdrawn) The method of claim 30 wherein the thermosetting film is heated to about 300°F.

37. (Withdrawn) The method of claim 30 wherein the wherein the thermosetting film is free of an acrylic adhesive.

38. (Withdrawn) The method of claim 30, wherein the flocked substrate is free of a hot melt adhesive.

39. (Withdrawn) The method of claim 38, wherein the applying step comprises heating the thermosetting film to a temperature at which the thermosetting film becomes tacky, but below a temperature at which the thermosetting film begins to cure and cross-link.

40. (Withdrawn) The method of claim 30, wherein in the providing step the flock is adhered to a transfer sheet by a release agent.

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41. (New) The flocked assembly of claim 1, wherein the thermosetting film is not adhered to a substrate.